

Work Order ID 66202

February 7, 2011 12:47:01 PM



Page 1

Item ID:	D4192-043	Accept		Setup	Start	
Revision ID:	PRELIM				Stop	
Item Name:	Adapter Plate Assembly, RH					
Start Date:	2/07/11	Start Qty:	2.00		Cust Item ID:	
Required Date:	2/18/11	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>CA</u>	Date:	<u>11/02/07</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100	Draw Nbr D4192	0.00							
	Revision Nbr PAT PAZ								
	BAND SAW	0.00				2	0		
	Memo Cut Blank to 4.350" Batch: 14252								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
	HAAS 1	0.00				2	0		
	HAAS CNC vertical machine #1								
	Memo 1-Machine per folio FA995 DWG REV: PAZ FOLIO REV: AA								
	2- deburr rough edges								



MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Cust Item ID:

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

As Remit Parts
To QM
No Rush ①

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	B.A	11/03/22		2	0		
130 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SL	11/03/22					②
140 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				2	BR	11-3-22	

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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							(2X) m-1 11/03/22
160 	Small Fab	0.00							
Small Fab	Memo	0.00							EP 11/03/29 (2)
	INSTALL ANCHOR NUTS & RIVETS AS PER DWG								
170 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo	0.00							- inspector b PA 2 Day only 8 11/03/29 11-04-05 PA3 (updated not plates)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

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Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Packaging Packaging	Identify as per dwg & Stock Location: <i>Pre Shell</i> Memo	0.00 0.00							
190 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

Final 11-06-08 2 7

RD 2334 R 11-06-9 2

POSITIVE RECALL
EFFECTIVE 11-06-08 AUTH W
RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 66202

Parent Item: D4192-043

Parent Item Name: Adapter Plate Assembly, RH

Start Date: 2/07/11

Required Date: 2/18/11

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-11-12 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

MS20426AD3-4 Purchased No



Rivet

Location

ST316

4179

4444

4533

Loc Qty

14148

2310

5678

6160

Loc Code

M 104374

100

f

53.0000

0.3625

0.725

M6061T6B0.750X03.00

0



6061-T6 Bar .750 x 3.00

Location

MAT02

104741

14252

15211

Loc Qty

53

21

12

20

Loc Code

Each

216.0000

8

MS21062-3K

Purchased

No



Nut Plate

Location

ST302

109590

Loc Qty

216

216

Loc Code

B 10-005086
(FROM EAGLE)

EP 3/10/03/29

1.725 on 2/11/03/24

EP 11/03/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 66202
Description: ADAPTER PLATE ASSEMBLY, RH		Part Number: D4192-3
Inspection Dwg: D4192, Rev: PA2 PA3 <i>Jul 11 04.05</i>		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
R0.03	+/- .030	R0.032	✓		R-G	ref.
0.13	+/- .030	0.124	✓		Mic	GA-03
0.93	+/- .030	0.935	✓		H-G	31006
R0.13	+/- .030	R0.125	✓		R-G	ref.
φ0.250	+0.005 / -0.001	φ0.251	✓		Vern	GA-01
0.22	+/- .030	0.214	✓		H-G	31006
0.25	+/- .030	0.251	✓		Vern	GA-01
43°	+/- 1/2°	43°	✓		Angle meter	CNC-03
0.25	+/- .030	0.251	✓		Vern	GA-01
2.624	+/- .010	2.624	✓		"	"
110°	+/- 1/2°	110°	✓		Angle meter	CNC-03
CSK0.179 x 100°	+/- .010 x +/- 1/2°	φ0.181 x 100°	✓		Vern	GA-01
φ0.098	+0.004 / -0.001	φ0.100	✓		"	"
R0.38	+/- .030	R0.375	✓		R-G	ref.
R0.25	+/- .030	R0.250	✓		"	"
0.312	+/- .010	0.312	✓		Vern	GA-01
0.344	+/- .010	0.344	✓		"	"
0.250	+/- .010	0.251	✓		Vern	GA-01
1.312	+/- .010	1.313	✓		H-G	31006
R0.25	+/- .030	R0.250	✓		R-G	ref.
R0.13	+/- .030	R0.125	✓		"	"
0.13	+/- .030	0.125	✓		Vern	GA-01
0.38	+/- .030	0.375	✓		"	"

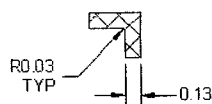
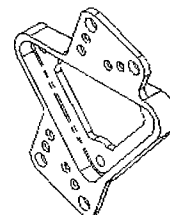
Measured by: B.A.
Date: 11/03/22

Audited by: <i>JK</i>
Date: 11/03/22

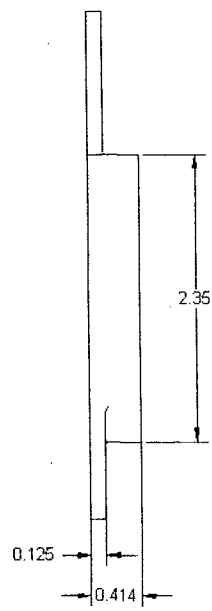
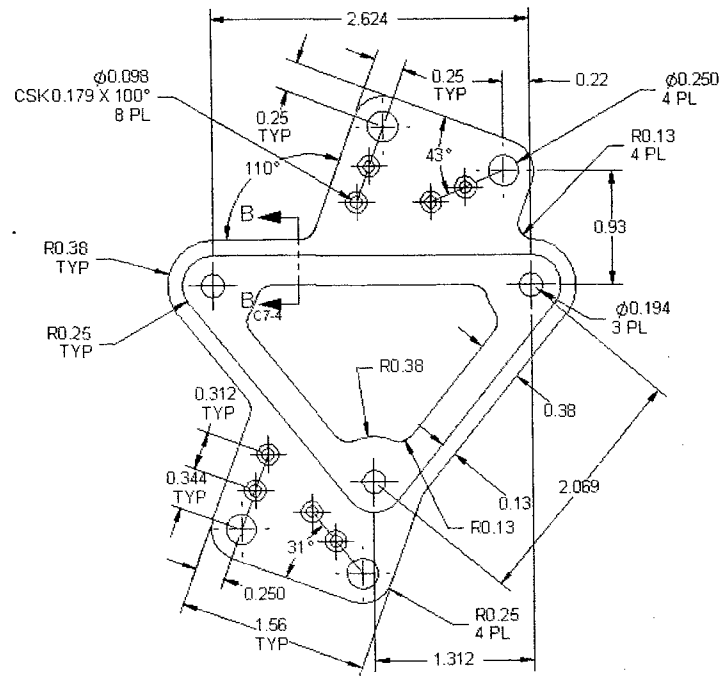
Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

w/o 66202



SECTION B-B C5.4



D4192-3 ADAPTER PLATE - RH

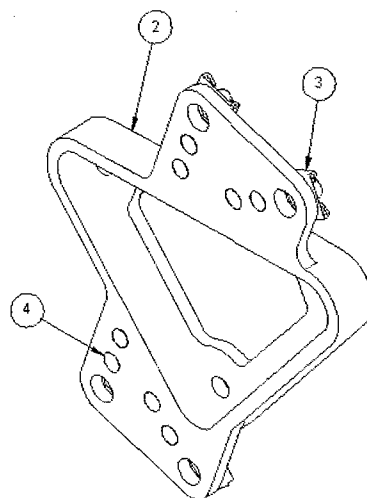
- NOTES:
- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/6
OR AMS 4117/4128/4115/4116
OR QQ-A-200/8 OR AMS-QQ-A-200/8
OR AMS 4160
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI005 4.1
 - 3) TOLERANCES: PER DART QSI018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.10 lbs

PRELIMINARY ISSUE
10.11.04

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. PA3
MFG. APPR.		D4192	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		ADAPTER	NTS
DATE	10.11.04	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS LOANED ON THE EXPRESS CONDITION THAT IT NOT BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4192-043	RH ADAPTER PLATE ASSEMBLY
2	1	D4192-3	ADAPTER PLATE - RH
3	4	MS21061L3	ANCHOR NUT
4	8	MS20426AD3-5	RIVET

W/066202



D4192-043 RH ADAPTER PLATE ASSEMBLY

PRELIMINARY ISSUE

10.11.04

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.11 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4192	REV. PA3
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		ADAPTER	NTS
DATE	10.11.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COMMERCE OR COMMUNICATIONS TO ANY OTHER PERSON OR ENTITY WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	